

July-10-12 9:11:09 AM

Item ID: D2576-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop ***NS2***

Item Name: Step (maching detail)

Start Date: 7/10/12

Start Qty: 50.00

50

Cust Item ID:**Required Date:** 8/17/12

Req'd Qty: 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/07/10 Tooling:

Date:

Stop ***NR2***

QC: _____

Date: _____ **SPC (Y/N):** _____

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July-10-12 9:11:10 AM

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step (maching detail)

Start Date: 7/10/12 **Start Qty:** 50.00

50

Cust Item ID:

Required Date: 8/17/12 **Req'd Qty:** 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: LC

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

^x50 0 3E 12/07/30

12/17/31

W1207.3e

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

July-10-12 9:11:09 AM

Page 1

Work Order ID: 86973

Parent Item: D2576-3

Start Date: 7/10/12

Required Date: 8/17/12

Parent Item Name: Step (maching detail)

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E 02.08.19Consolidated D2576-1 and D2576-3 KJ/RF

IPP Rev:D As per Rev G 07-09-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1 Step (casting detail)		Manufactured	No			100	Each	0.0000	1	50			

86938 X 50

OK 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

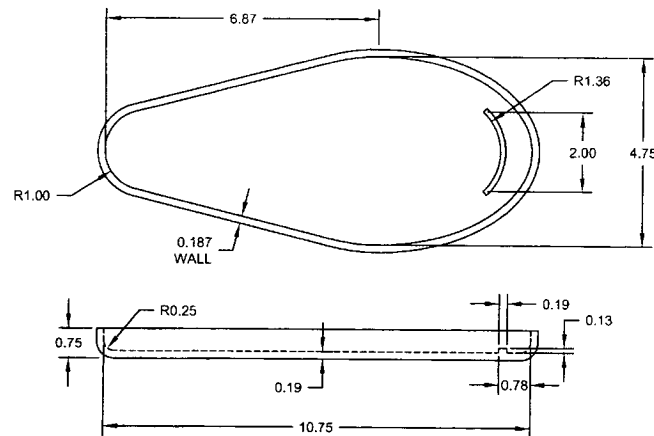
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

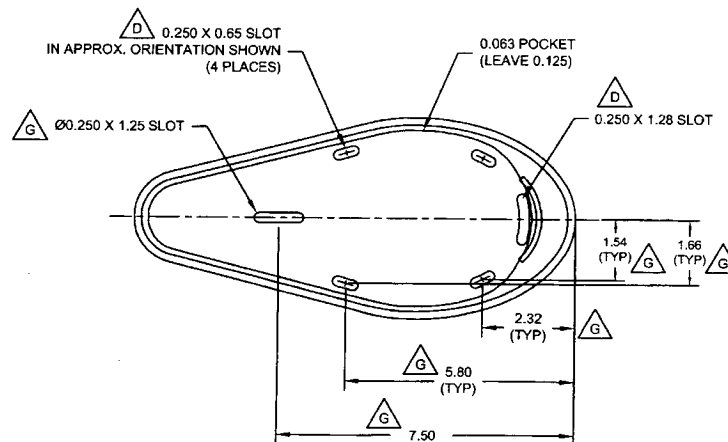
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **86973** **MLJ**
12/07/10

RELEASED

07.08.29

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. G D2576 SHEET 1 OF 1 TITLE SCALE STEP 1:3 COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	J		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	J		
DE APPR.	J		
DATE	07.08.15		

W/O:		WORK ORDER CHANGES					
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